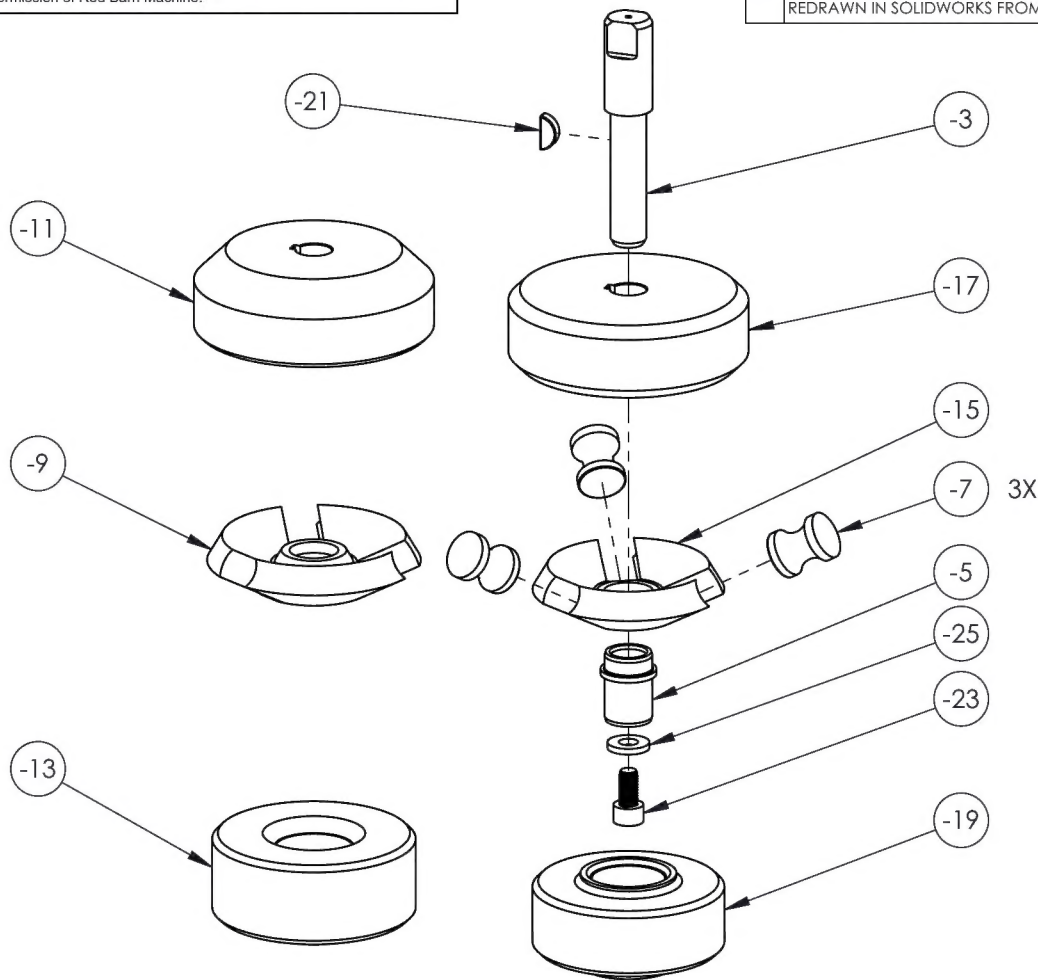


This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
	REDRAWN IN SOLIDWORKS FROM TATTERED ORIGINAL DWG.	8/30/2013	CFS



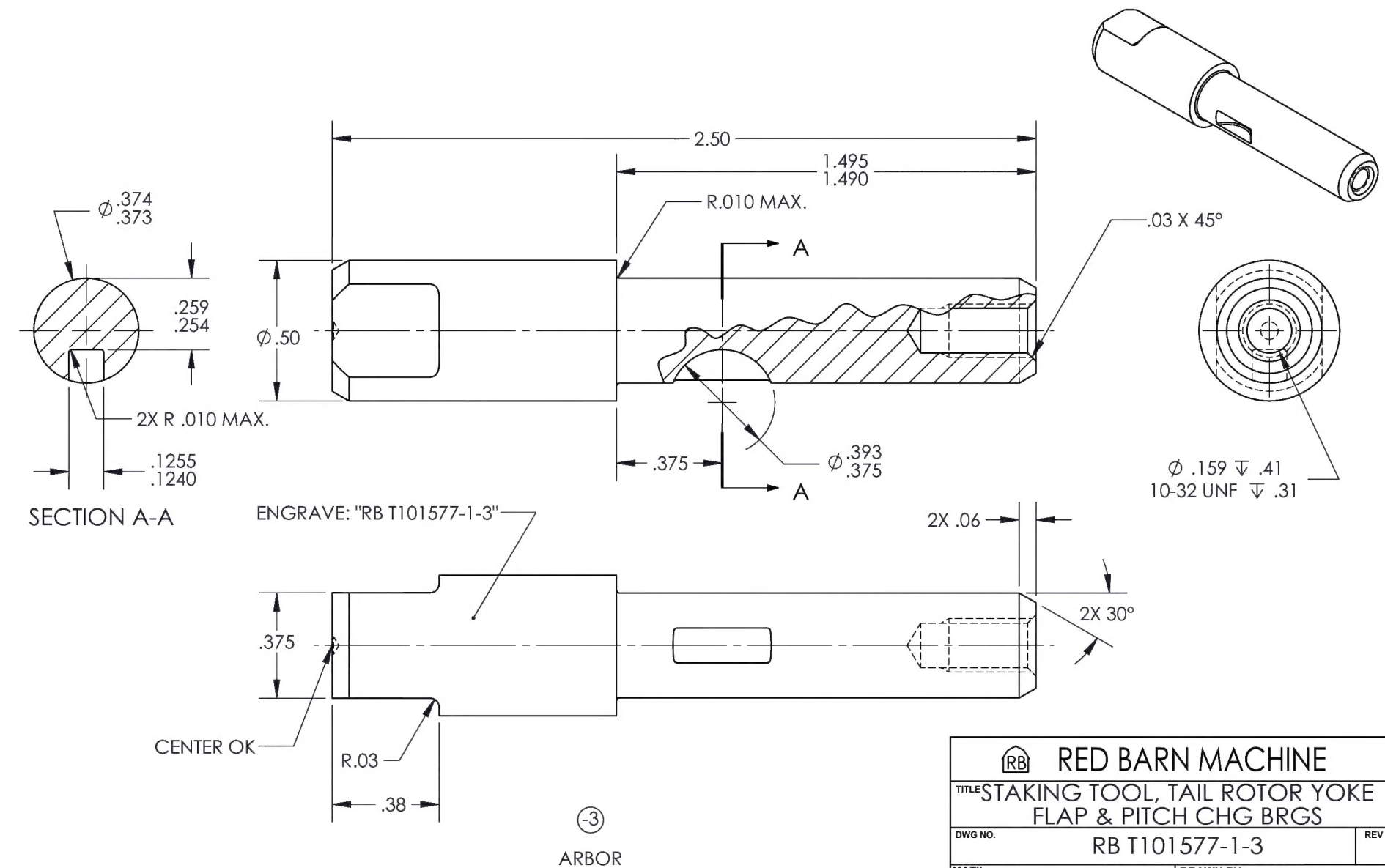
NOTE:  
1. USED ON MODEL: BELL 205A1, 212, 214B, 222, 222B, 222U, 230, 407, 412, & 430.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	ARBOR	01	Ø5/8 X 2-3/4	2
			-5	1	BUSHING	ALUM. BRONZE	Ø5/8 X 1	3
			-7	3	ROLLER	01	Ø5/8 X 3/4	4
			-9	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	5
			-11	1	HOUSING	01	Ø2-5/8 X 1-1/4	6
			-13	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	7
			-15	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	8
			-17	1	HOUSING	01	Ø2-5/8 X 1	9
			-19	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	10
		B/O	-21	1	WOODRUFF KEY	STEEL	#213 WOODRUFF KEY MCMASTER-CARR #98525A075	1
		B/O	-23	1	SOCKET HEAD CAP SCREW	S.S.	#10-32 X 3/8 MCMASTER-CARR #92200A340	1
		B/O	-25	1	FLAT WASHER	STEEL	Ø.438 X .063 AIRCRAFT SPRUCE #AN960-10	1

		<b>RED BARN MACHINE</b>	
<b>TITLE</b> STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS		<b>REV</b>	
<b>DWG NO.</b> RB T101577-1		<b>APPROVED</b> <i>D Weil</i>	
<b>MAT'L</b>		<b>DRAWN BY:</b> SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± 5° .X ± .1		<b>HEAT TREAT</b>	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>FINISH</b>	
<b>SCALE</b> 1:2		<b>SPEC</b>	
<b>DATE</b> 8/26/2013		<b>USED ON MODEL</b>	
<b>SHEET 1 OF 10</b>		<b>SEE NOTE</b>	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

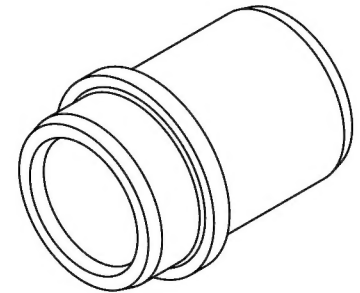
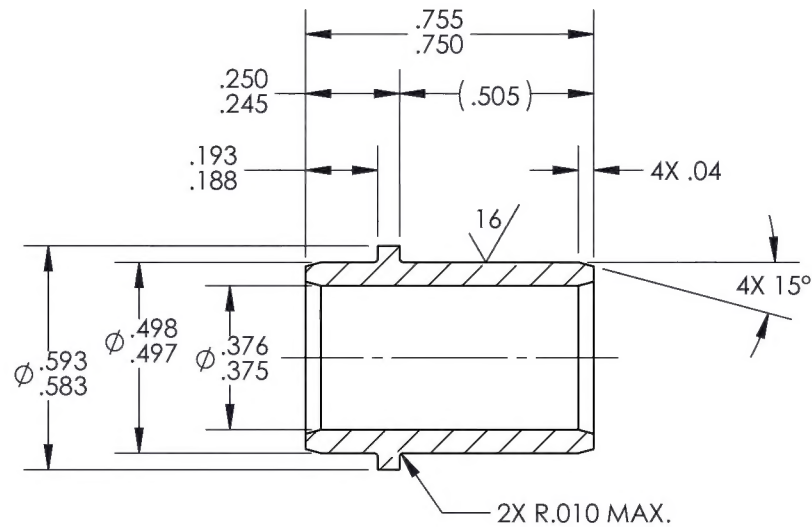
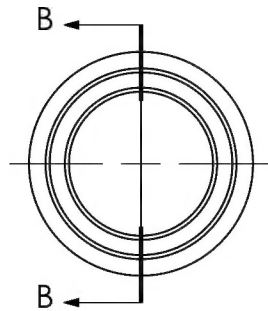
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



<b>RED BARN MACHINE</b>	
TITLE <b>STAKING TOOL, TAIL ROTOR YOKE FLAP &amp; PITCH CHG BRGS</b>	
DWG NO. <b>RB T101577-1-3</b>	REV
MAT'L 01	DRAWN BY: <b>SMITH</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT <b>RC 58-62</b>
.XX ± .03	FINISH <b>BLACK OXIDE</b>
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE <b>2:1</b>	DATE <b>8/26/2013</b>
SHEET 2 OF 10	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



SECTION B-B

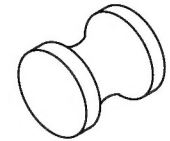
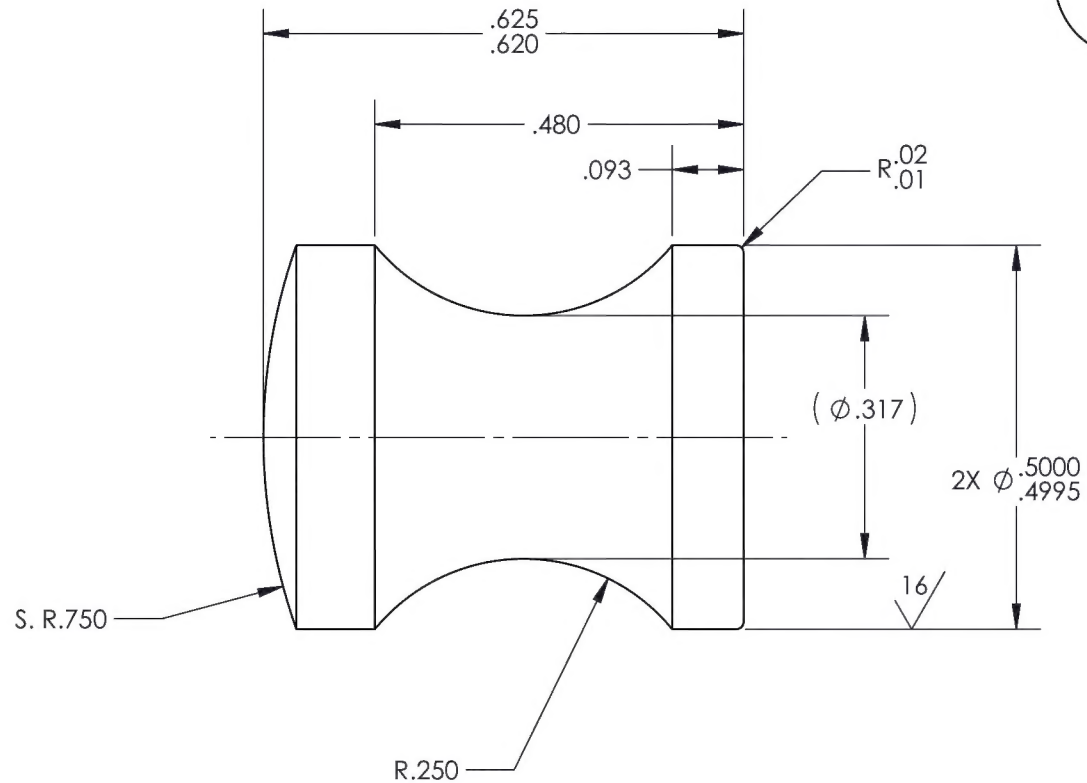
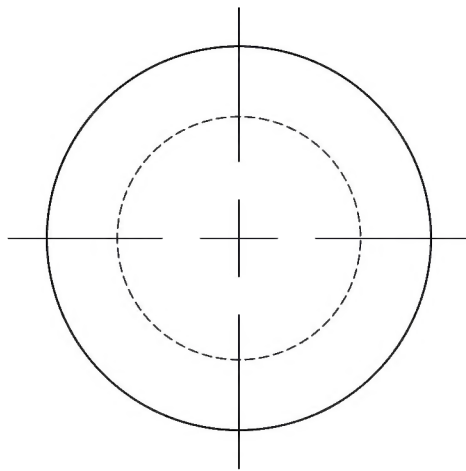
(-5)

BUSHING

<b>RED BARN MACHINE</b>	
TITLE <b>STAKING TOOL, TAIL ROTOR YOKE FLAP &amp; PITCH CHG BRGS</b>	
DWG NO. <b>RB T101577-1-5</b>	REV
MAT'L <b>ALUM. BRONZE</b>	DRAWN BY: <b>SMITH</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE <b>2:1</b>	DATE <b>8/26/2013</b>
SHEET 3 OF 10	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



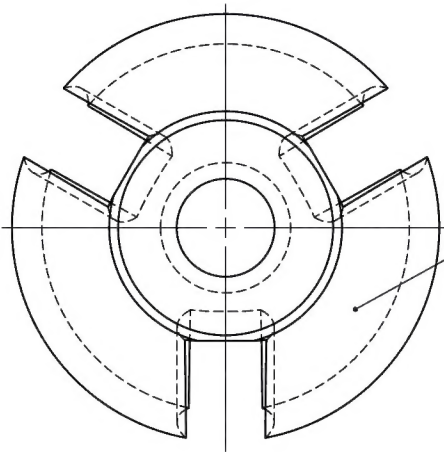
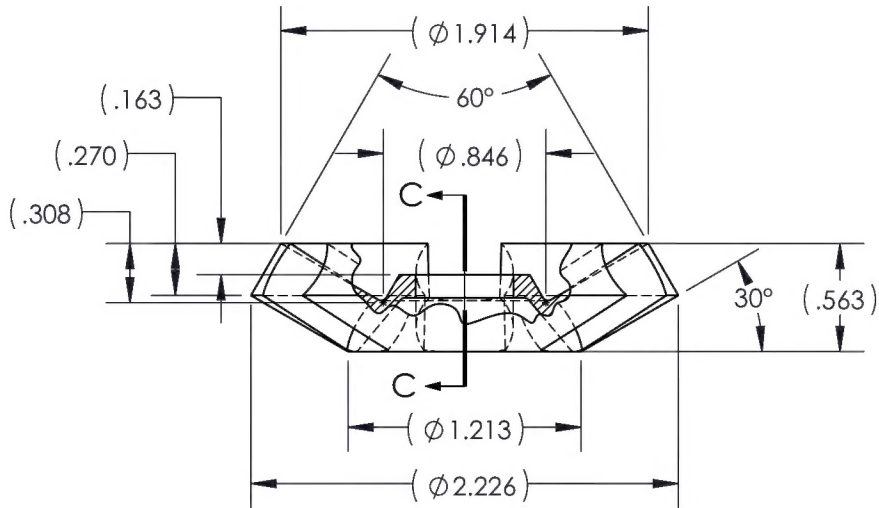
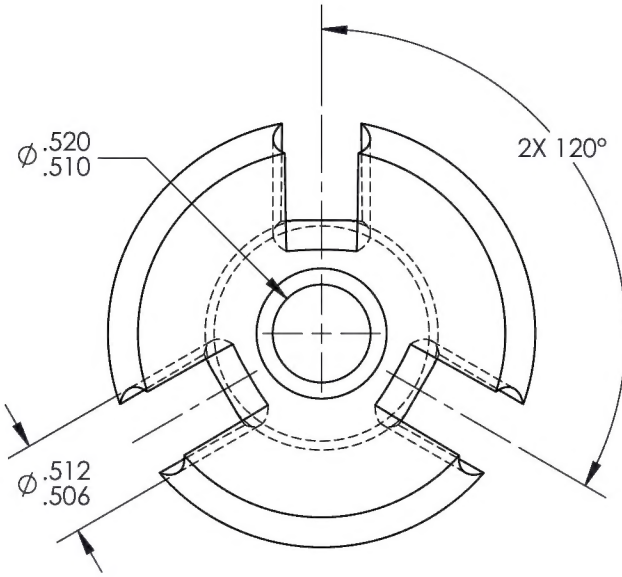
(-7)

ROLLER

<b>RED BARN MACHINE</b>	
<b>TITLE</b> STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
<b>DWG NO.</b> RB T101577-1-7	<b>REV</b>
<b>MAT'L</b> 01	<b>DRAWN BY:</b> SMITH
<b>UNLESS OTHERWISE SPECIFIED</b> <b>DIMENSIONS ARE IN INCHES</b> .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± 5° .X ± .1	<b>APPROVED</b> <i>D Weil</i> <b>HEAT TREAT</b> RC 58-62 <b>FINISH</b> <b>SPEC</b>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> 2:1	<b>DATE</b> 8/26/2013
<b>SHEET 4 OF 10</b>	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

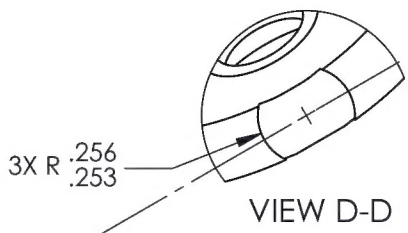
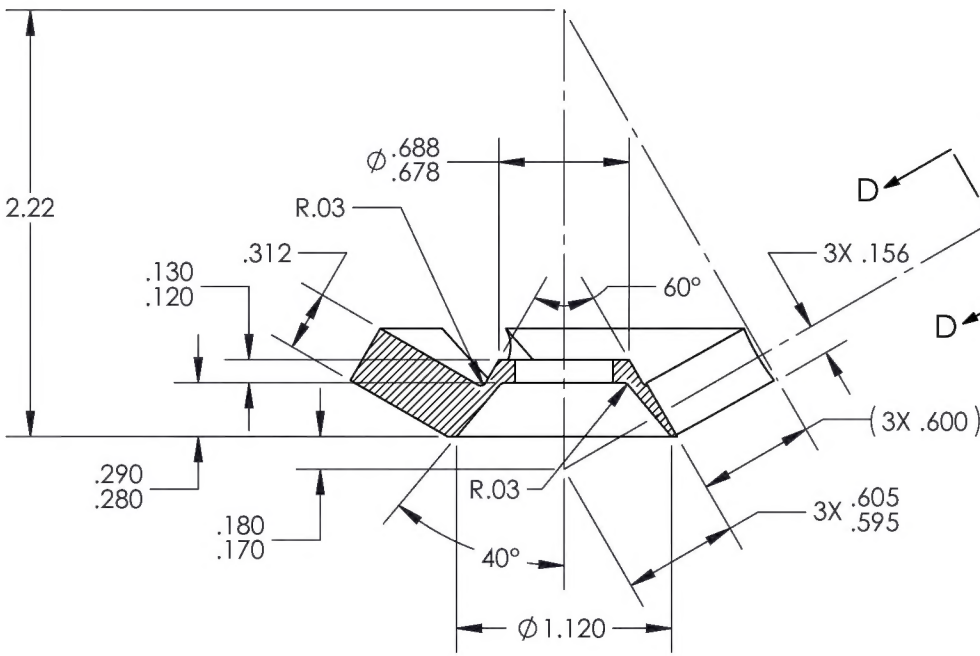
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



ENGRAVE: "RB T101577-1-9"

-9

RETAINER



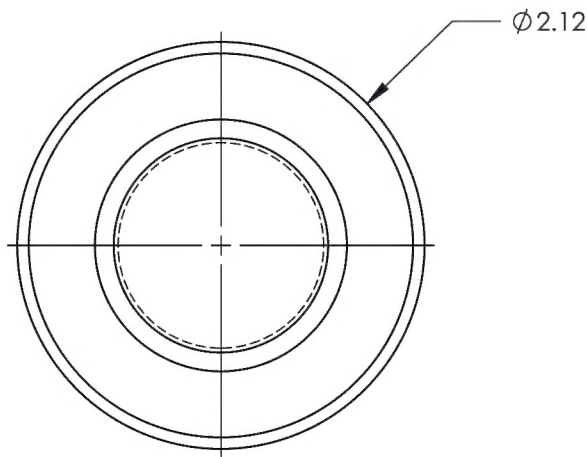
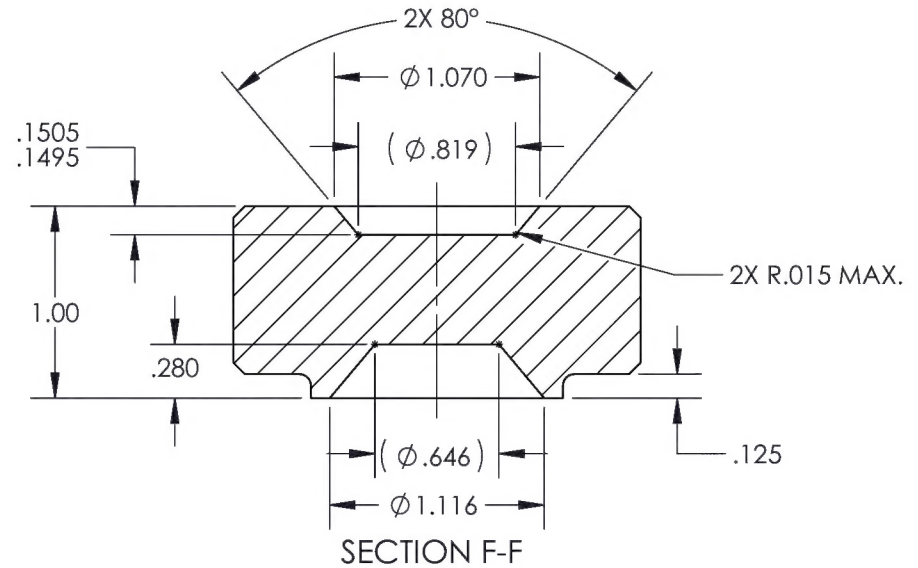
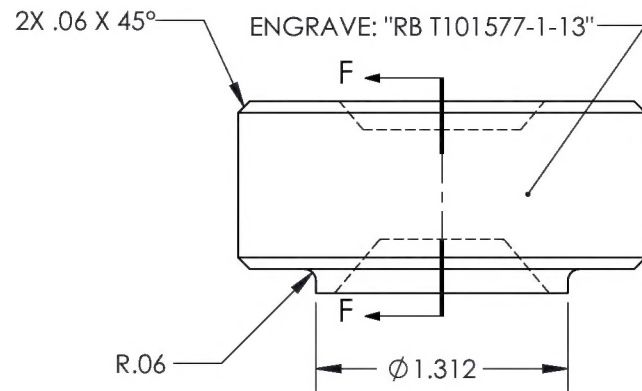
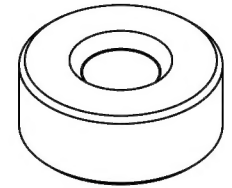
RED BARN MACHINE				
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS				
DWG NO. RB T101577-1-9				REV
MAT'L ALUM. BRONZE		DRAWN BY: SMITH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>		
.XXX ± .010		HEAT TREAT		
.XX ± .03		FINISH		
.X ± .1		SPEC		
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING				
SCALE 1:1	DATE 8/26/2013	SHEET 5 OF 10		





This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

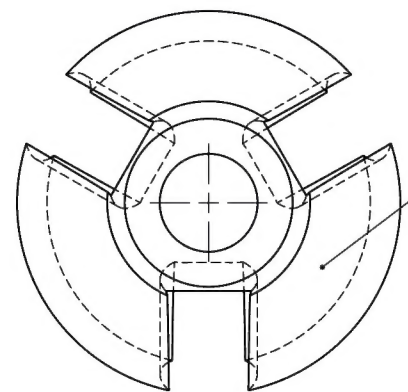
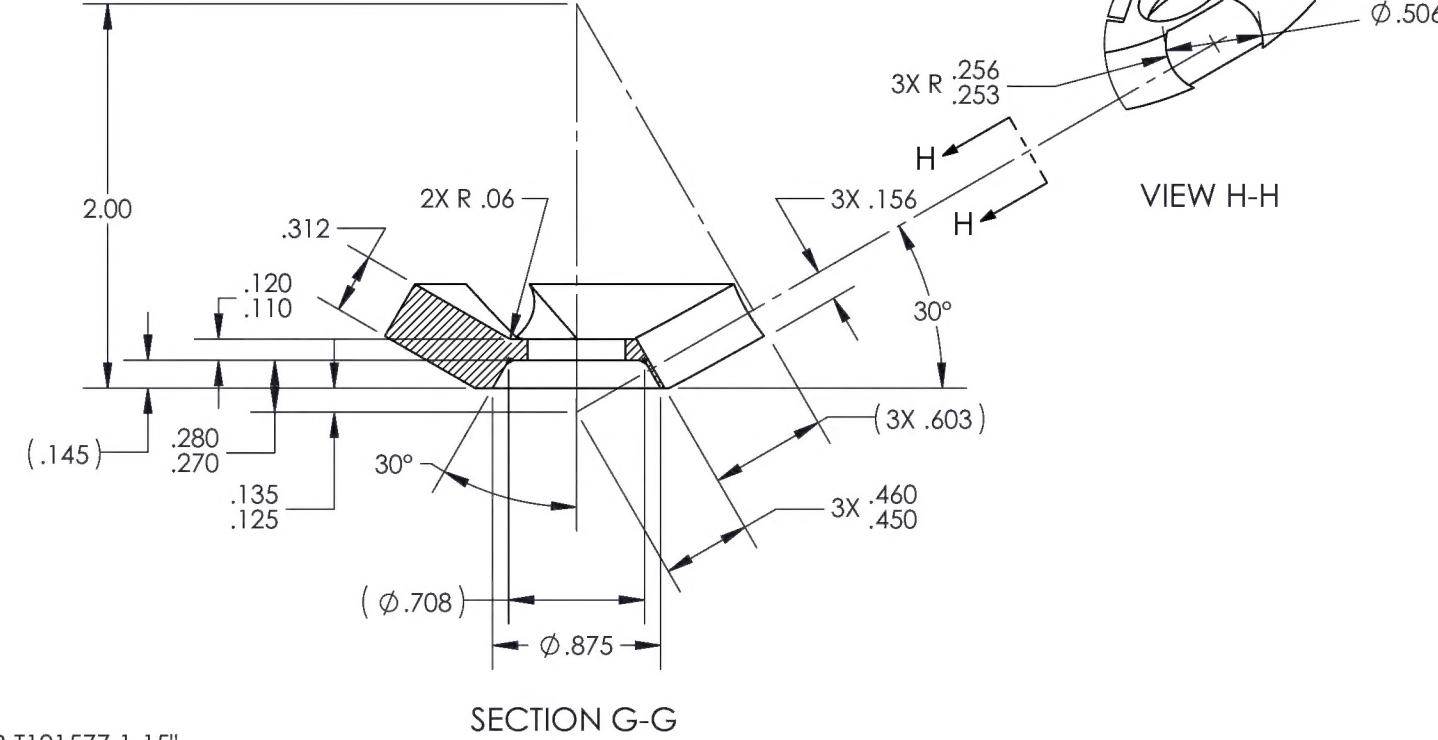
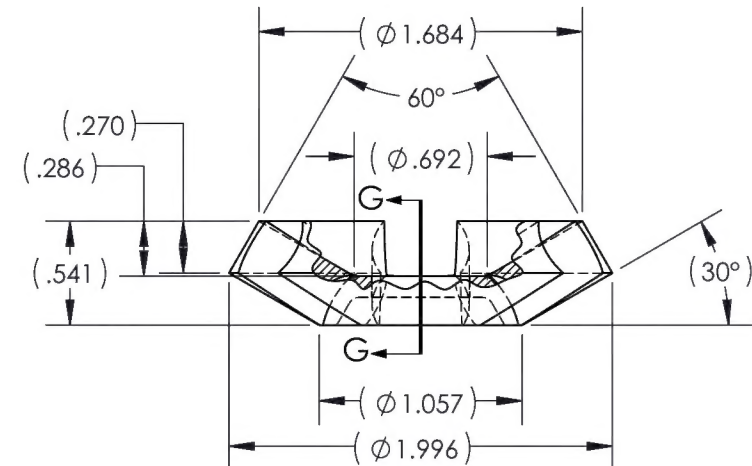
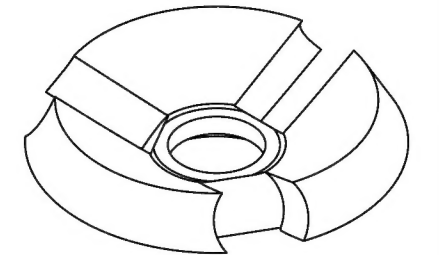
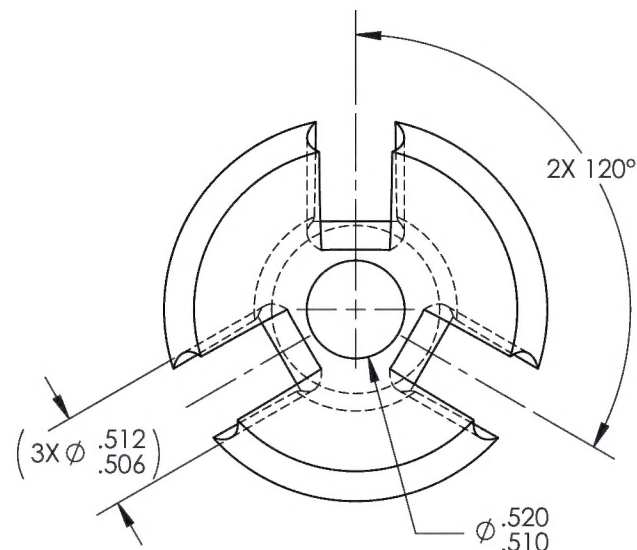


(-13)  
BACK STOP

<b>RED BARN MACHINE</b>	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-13	
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT
.XX ± .03	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 7 OF 10	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



ENGRAVE: "RB T101577-1-15"

(-15)

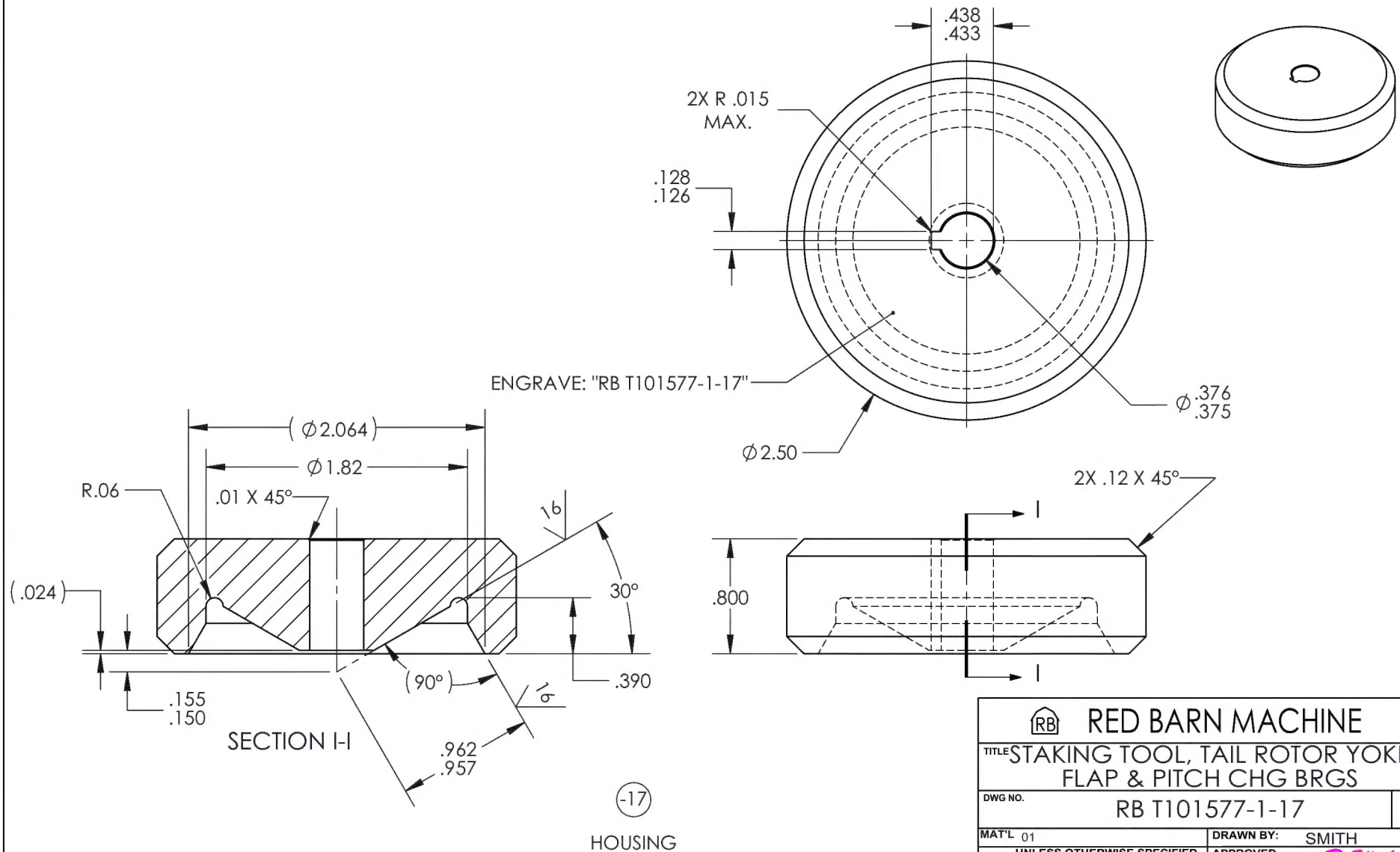
RETAINER

RED BARN MACHINE			
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS			
DWG NO. RB T101577-1-15			REV
MAT'L ALUM. BRONZE		DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .010 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .03 ANGLES ± .5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:1	DATE 8/26/2013	SHEET 8 OF 10	



This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

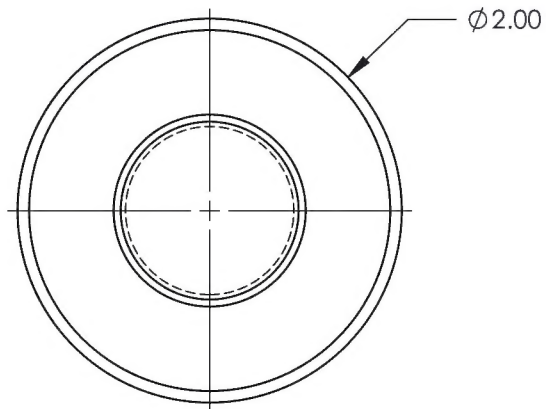
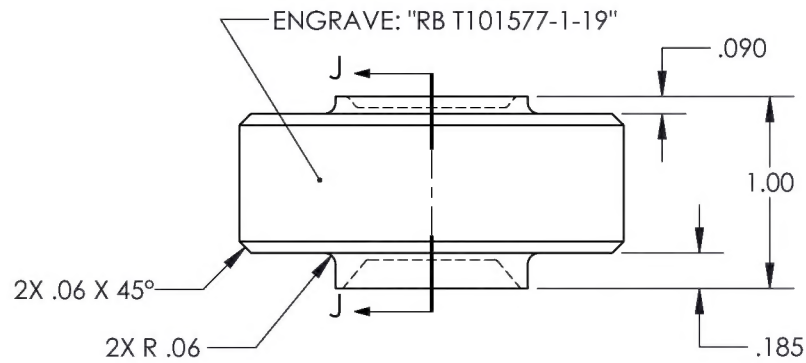
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



<b>RED BARN MACHINE</b>	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-17	
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D Weil</i>
.XXX ± .010	HEAT TREAT: RC 58-62
.XX ± .03	FINISH: BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 9 OF 10	

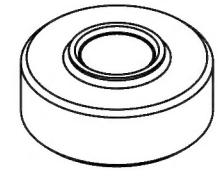
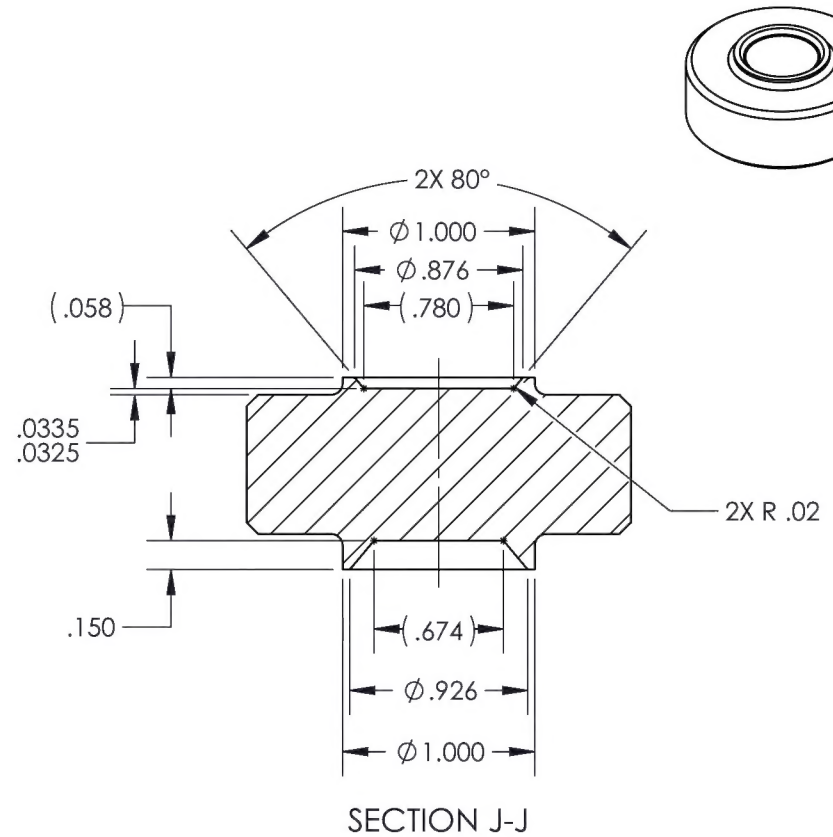
This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



-19

BACK STOP



<b>RED BARN MACHINE</b>	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-19	
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 10 OF 10	